Work Orde Wednesday, June				*120	153*						Page 1
<b>Revision ID:</b>	D3492-5			Accept	*N900	040	100	<b>)*</b> s	Setup Star		S1*
	Plug 6/04/14 6/04/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item :				Sto	"IXI	S2*
Approvals:	Process Pla	in: MLJ	Date: <u>14-06-05</u>	Tooling:	D	ate:		R	tun Star	~1 <i>\</i> J	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:			Sto	, *N	R2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3492	E										
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	Small	Hardinge CNC LATHE S  Memo 1-Turn as pe Dwg Rev: Folio Rev:	er Folio FA634 & Dwg D349	0.00	ĺ	DAS <b>20</b> 9-89 4-06-14		42	Ø		
110 <b>*110*</b> QC Quality Control		QC2- Inspect parts off m  Memo	achine FAI/FAIB	0.00		DAS <b>20</b> 9-89 14-00-14	(	42	Ø		<u>J</u> -
120 *1 <b>2</b> 0*		QC8- Inspect parts - seco	and check	0.00				42	ø		DAS 40 9-89
Quality Control		Мето		0.00					,		14/06/15

DQA:			Date:										TA PT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order u	odate only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
	•					Rework			Skid-tube Crosstube		]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	ю.					Suspected Unapproved			Large Fab Composite		j	Supplier	
Root					Desci	iption of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data	_										1		
Equip/Tooling													
Handling/Pre	_						İ						
Material													
Operator				1		. **±							
Offset/Setup			1			est.							
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Supplier			}										
Training													
Transport				Ī									
Unapproved	_			l	1	4		UT CA	l Tegory			<u> </u>	<u> </u>
1				-	•	OS General	FA	OLI CA	TEGORY			· » <del>- · · ·</del>	
Landi		Bending				Bend		Folio/	Program	Г	Outside Dim	ensions [	Pressure/Forced
		Centre No	nt Conce	ntric		BOM/Route	H	Grain	Togram	H	Over/Under		Set-up
		Cracks	or contect	intine		Broken/Damage/Defect		Hardwa	are	-	Part Incorre	<del> </del>	Temperature/Cure
	_	Crimp/Kir	nk/Rinnle	/Wave		Burrs	$\vdash$	4	ion Incomplete/Unqualified	H	Part Lost/M	<u> </u>	Weld
	⊢	Cuffs	пу прртс	., <b>., .,</b>		Contamination		1	tions Incomplete/Unclear	Г	Part Moved		Wrong Stock Pulled
	_	Crushing			-	Countersink		4	gned/off center	r	Positioned V	ــــ Vrong	<b>-</b>
		Heat Trea	it			Cut Too Short	T	Mislab			Power Loss/		Other
	-	Inspection		Tube		Drawing	<u> </u>	Misrea	*	_	_	-	•
		Marks/Ch				Drill Holes		Off-set			`	*.	
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	rist in Tul	be		Fit/Function		Out of	Sequence				

Work Order ID 120153 \*120153\* Wednesday, June 04, 2014 2:57:06 PM Item ID: D3492-5 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Plug \*40\* **Start Date:** 6/04/14 **Start Oty: 40.00 Cust Item ID:** Required Date: 6/04/14 Req'd Qty: 40.00 \*40\* **Customer:** Reference: Run Process Plan: **Approvals:** Date: Tooling: Date: Stop Date: SPC (Y/N): Date:\_ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code 150 Chemical Conversion Coat per QSI005 4.1 0.00 \*150\*

0.00

0.00

0.00

160

\*160\*

Powdercoat

HandFinish

Hand Finishing

Powder Coating

\*170\*

170

OC

Quality Control

White Gloss(Ref:4.3.5.1) per QSI00534.3-Alum

Memo

Memo

(Flat End Only) START TIME:

OVEN TEMPERATURE FINISH TIME:

QC3- Inspect Part Finish

Memo

DAS 27

Page 2

42. 6 14-6-24

Work Order:    Part No.	DQA:		_ Date:										<i>/</i> 2/	DART
Work Order:    Part No.						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				<del></del>	AEROSPACE
Part No.	QA Closed:		Date:	**						Wo	ork Order up	date only		
Rework Scrap Use-as-is Suspected Unapproved Description of work order update Cause Date Step Qty Or non-conformance Orientalized Description of work order update or non-conformance Orientalized Description Description Description of work order update or non-conformance Orientalized Description Description Description Orientalized Description Descriptio	Mark Order					DISPOSITION			AGAINS	ST DE	PARTMENT,	/PROCESS		
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NCR No.    Suspected Unapproved   Suspected Unapproved   Large Fab   Composite   Supplier   Other	Part No.					<u> </u>	1		<b>—</b>		Pro	<u> </u>	<b>-</b>	
Root Cause Date Step Qty Description of work order update or non-conformance Design Doc/Data Cause Date Step Qty Or non-conformance Design Doc/Data Cause Do	1 411110	•				· •	1	1	<b>Ŭ</b> —	<b>)</b>		<u>-</u>		Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Hall Inspector Equip/Tooling Heat Treat  Design Doc/Data Equip/Tooling Hall Inspector Heat Treat  Design Doc/Data Equip/Tooling Hall Inspector Heat Treat  Description Date Verification QC Inspector  Date Verification QC Inspector  Design Doc/Data Equip/Tooling Hall Inspector Hall Inspector Hall Inspector Hall Inspector Hall Inspector Heat Treat  Description Date Verification QC Inspector  Date Verification QC Inspector  Date Verification QC Inspector  Doc Inspector  Date Verification QC Inspector  Date Verification QC Inspector  Doc Inspector  Date Verification QC Inspector  Doc Inspector  Doc Inspector Incomplete/Unqualified Instructions In	NCR No					Suspected Unapproved	]		Large Fab Composi	te		Supplier		
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Hall Inspector Equip/Tooling Heat Treat  Design Doc/Data Equip/Tooling Hall Inspector Heat Treat  Design Doc/Data Equip/Tooling Hall Inspector Heat Treat  Description Date Verification QC Inspector  Date Verification QC Inspector  Design Doc/Data Equip/Tooling Hall Inspector Hall Inspector Hall Inspector Hall Inspector Hall Inspector Heat Treat  Description Date Verification QC Inspector  Date Verification QC Inspector  Date Verification QC Inspector  Doc Inspector  Date Verification QC Inspector  Date Verification QC Inspector  Doc Inspector  Date Verification QC Inspector  Doc Inspector  Doc Inspector Incomplete/Unqualified Instructions In			-											****
Design   Doc/Data   Equipy Todoling   Handling/Pre   Material   Operator   Offset/Setup   Process   Supplier   Training	Root				Desc	·					_			
Doc/Data   Equip/Tooling   Handling/Pre   Material   Operator	Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification		QC Inspector
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Handling/Pre Material Operator Offset/Setup Process Supplier Training Training I Unapproved Pant Category  Landing Gear General  Bending Centre Not Concentric Cracks Droken/Damage/Defect Set-up Broken/Damage/Defect Hardware Part Incorrect Temperature/Curè Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Part Moved Wrong Stock Pulled Power Loss/Surge Other	Doc/Data	4												
Material Operator Offset/Setup Process Supplier Trainsport Unapproved FAULT CATEGORY  Landing Gear General Sending Gear General Outside Dimensions Over/Under tolerance Set-up Hardware Part Incorrect Temperature/Curè Description (Cracks Crimp/Kink/Ripple/Wave Durrs Unspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Positioned Wrong Stock Pulled Power Loss/Surge Other	Equip/Tooling	_												-
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Transport Unapproved	Supplier	_												
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I Improvious strip in ruse   Internity   Interests	<b> </b>	<b>⊣</b>		Tuhe	$\vdash$	4	-	-		<u> </u>	1. 22, 5033/	·· O+ _	1	-
Marks/Chatter Drill Holes Off-set	-	<b>⊣</b> '		1450	-			-						
Turning Sequence Finish Out of Calibration	<b> </b>				-			-1				-	<u> </u>	
Wave/Twist in Tube Fit/Function Out of Sequence	<del> </del>	<b>⊣</b> ັ	•					-					-	

W	0	rk	•	Order	•	ID	)	1	2	01	.5	3
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Quality Control

## \*120153\*

Page 3

Wednesday, Jun	e 04, 2014 2	2:57:06 PM			<i>,</i> , , , , ,						8
Item ID: Revision ID:	D3492-5	·	4	Accept	*N900	<b>0401</b>	<b>)</b> 0*	Setup	Start	*N:	S1*
Item Name:	Plug								Stop	*\\!	S2*
Start Date:	6/04/14	<b>Start Qty:</b> 40.00	*40*		Cust Item II	<b>D</b> :					,
Required Date:	6/04/14	Req'd Qty: 40.00	*40*		<b>Customer:</b>						
Reference:											
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:			Start		R1*
3	QC:		Date:	<b>SPC</b> (Y/N):	Da	te:	_		Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla		pt Rejec		Reject Number	Insp. Stamp
180		Identify as per dwg & Sto	ock Location: FP-00	0.00					1	00 1	
*120* Packaging		Memo		0.00				42 (		<u> </u>	1406/28
Packaging											
190 '		QC21- Final Inspection -	Work Order Release	0.00							
*190*							A.	115		400	6-25
QC		Memo		0.00				<u></u>		-, -, -	

14.06.24

DQA:			Date:											TRAGG"
						WORK ORDER NON	-CC	ONFO	RMANCE / UPE			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
						DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Orde	r: -					<b></b>	1		cuia auto	Cuanaturba	1	Water Jet	$\neg$	Engineering
Down N						Rework	1		Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	$\dashv$	Quality
Part N	0.					Scrap Use-as-is	1		noforming	Finishing	4	e/Packaging	$\dashv$	Other
NCR N	0					Suspected Unapproved	1	Inch	· —	Composite	11.00,010.	Supplier	ヿ	
l itenti	•			•••		Suspected Onapproved	ן נ		zarge i an		1		_	Ш
Root			-		Desc	ription of work order update		nitial	Actio	n	Sign &	-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	<u>1</u>	QC Inspector
Design														
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Equip/Tooling														
Handling/Pre														
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Operator	_												ł	
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							FA	ULI CA	TEGORY		<u></u>			
Landir						General		احمانہ ا	Program		Outside Dim	onsions [		Pressure/Forced
<u> </u>	_	Bending	- <b>.</b>	. Auf a	$\vdash$	Bend BOM/Bouto	-	Grain	Program	<u> </u>	Over/Under	- F		Set-up
}		Centre No	ot Concer	itric	$\vdash$	BOM/Route Broken/Damage/Defect		Hardwa	aro.	-	Part Incorre	F	_	Temperature/Cure
-		Cracks Crimp/Kir	sk/Binnlo	/\\/ava	$\vdash$	Burrs		4	tion Incomplete/Unq	ualified	Part Lost/Mi	F	-	Weld
	_	Cuffs	ik) vihbie	/ vvave	_	Contamination	$\vdash$	1	tions Incomplete/Un		Part Moved	-	-	Wrong Stock Pulled
	$\overline{}$	Crushing			$\vdash$	Countersink	$\vdash$	4	gned/off center	_	Positioned V	L Vrong		
}		Heat Trea	at		-	Cut Too Short	$\vdash$	Mislab	-	-	Power Loss/		<u> </u>	Other
		Inspection		Tube	-	Drawing		Misrea		<u> </u>	···	٠ .		
	_	Marks/Ch	•			Drill Holes		Off-set						
	-	Turning S				Finish		4	Calibration					
		Wave/Tw				Fit/Function		- 1	Sequence					

**Picklist Print** 

Wednesday, June 04, 2014 2:57:06 PM

Work Order ID: 120153

\*120153\*

Parent Item:

D3492-5

Parent Item Name: Plug

\*D3492-5\*

**Start Date:** 6/04/14

Required Date: 6/04/14

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

**Comments:** 

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.375		Purchased	No			100	f	21.0550	0.06	2.526316		D/	
*M6061T6	SR0 375	*							**	2.9581		<b>2</b> 94	

6061-T6 Round Bar .375"

Location	Loc Oty	Loc Code	
MAT012	21.055		
123483	2.5		
m128054	18.555		₹ 2.958

DQA:			. Date:			•			_				7	DART
			Data			WORK ORDER NON	-C(	ONFO	RMANCE / UI		ork Order up	ndata anly	_	AEROSPACE
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·				vv	ork Order up	date only		<del></del>
Work Orde	۶r.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•	
Work Orac						Rework	1		Skid-tube	Crosstube	7	Water Jet	٦ E	ngineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	┪ ¯	Quality
""	•••					Use-as-is	1		noforming	Finishing		re/Packaging		Other
NCR N	٠ No.					Suspected Unapproved	1		Large Fab	Composite	† ′	Supplier		
	•					' ' -			·		_	· · · · ·		
Root	:::	C C			Desc	ription of work order update		Initial	Act	ion	Sign &			
Cause	Ü	Date	Step	Qty		or non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	,	QC Inspector
Design	ţ.	r,'												
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Equip/Tooling						•	1			ige.				
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Material					`									
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Offset/Setup														
Process					İ									
Supplier						•								
Training														
Transport												·		
Unapproved	Ŀ		<u> </u>	<u> </u>			1		<u> </u>		<u> </u>			
						· · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY					
Landi	ng G	1			·	General	_	7 /-	_		7		٦.	
		Bending	_	_	_	Bend	$\vdash$	-1	Program	<u> </u>	Outside Dim	<b>⊢</b>	_	essure/Forced t-up
	Щ	Centre No	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain			Over/Under	t-	_	•
		Cracks			-	Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorre	<b>—</b>	-\\We	mperature/Cure
	_	Crimp/Kir	nk/Rippie	/Wave	-	Burrs	$\vdash$	-	ion Incomplete/Ur	<u> </u>	Part Lost/M	issing	-	ong Stock Pulled
	<u> </u>	Cuffs			-	Contamination	$\vdash$	4	tions Incomplete/l	Unclear	Part Moved	L Vrang	v	ong stock Pulled
	-	Crushing			-	Countersink Cut Too Short	-	Mislab	gned/off center	<u> </u>	Positioned V Power Loss/		Otl	ner .
	$\vdash$	Heat Trea		Tuba	$\vdash$	4	$\vdash$	Misrea		Ĺ_	Trower ross/	Juige [	Jou	ICI
	$\vdash$	Inspectio Marks/Ch		rube	$\vdash$	Drawing Drill Holes	$\vdash$	Off-set						
	_	Turning S			<b>H</b>	Finish	-	-	Calibration			<del></del>		
	$\vdash$	Wave/Tw			-	Fit/Function	$\vdash$	-1	Sequence	٠				
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DART AEROSPACE LTD	Work Order:	120153
Description: Plug	Part Number:	D3492-5
21		
Inspection Dwg: D3492 Review E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	-375			Nex	22-10
Ø0.188	+0.005/-0.001	188			~	, ,
0.045	+0.000/-0.002	044			-	
0.500	+/-0.010	.500				
0.060	+/-0.005	-060				
0.060	+/-0.005	-O(e)				
0.090	+0.000/-0.002	.089				
		•				
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						·

Measured by:	L	Audited by:	40	ſ	Preliminary Approval:	
Date:	14-6-13	Date:	14/06/15		Date:	

Rev	Date	Change	Revised by	Approved
Α	06.07.11	New Issue P/O D3492-045	KJ/JLM	1.10.10.10.10.10.10.10.10.10.10.10.10.10
В	06.10.16	Updated to Revision B	. KJ/JLM	
C	07.10.30	Tolerance revised for Ø0.375	KJ/EC/DD	
D	08.11.28	Dwg Rev updated	KJ/EC . A	/ lall
E	11.06.21	Dwg Rev updated	KJ KJ	

D3492-XX PLUG (SEE TABLE)-NAS1611 O-RING (SEE TABLE)

**D3492-XXX PLUG PARTS LIST** 

								OT AILIO LIGI		
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION	
X								D3492-041	PLUG ASSEMBLY	7
	Х							D3492-043	PLUG ASSEMBLY	7
		Х						D3492-045	PLUG ASSEMBLY	7
			Х					D3492-047	PLUG ASSEMBLY	7
				Х				D3492-049	PLUG ASSEMBLY	7
					Х			D3492-051	PLUG ASSEMBLY	٦
						X		D3492-053	PLUG ASSEMBLY	٦.
							Х	D3492-055	PLUG ASSEMBLY	7£
1								D3492-1	PLUG	
	1							D3492-3	PLUG	
		1						D3492-5	PLUG	
			1					D3492-7	PLUG	
				1				D3492-9	PLUG	
					1			D3492-11	PLUG	
						1		D3492-13	PLUG	
							1	D3492-15	PLUG	]&
										4
		. 1						NAS1611-005	O-RING	_
			1					NAS1611-007	O-RING	4
1								NAS1611-010	O-RING	4
						1		NAS1611-012	O-RING	4
	1							NAS1611-013	O-RING	1
					1		1	NAS1611-015	O-RING	
				1				NAS1611-016	O-RING	7

 $\frac{\text{NOTES}}{1)}$  O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 120 153 MLJ 1406-05

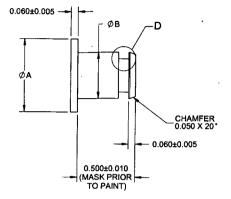
Ε	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

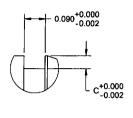
DESIGN	PH	DART AEROS	SPACE LTD
DRAWN	AP	HAWKESBURY, ON	
CHECKED	455	DRAWING NO.	REV. E
MFG. APPR.	<i>B</i>	D3492	SHEET 1 OF 2
APPROVED	149	TITLE	SCALE
DE APPR.		PLUG	NTS
DATE 13.0	8.08	COPYRIGHT © 2007 BY D THIS DOCUMENT IS PRIVATE AND COMPONITIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OF	SUPPLED ON THE EXPRESS CONDITION THAT IT IS

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POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

## **D3492-XX PLUG**

## **D3492-XX PLUG MACHINING DETAILS**

	MATERIAL SPEC	С	В	A	P/N
	M6061T6R0.625	0.050	0.394	0.625	D3492-1
	M6061T6R0.750	0.045	0.582	0.750	D3492-3
	M6061T6R0.375	0.045	0.188	0.375	D3492-5
$\neg$	M6061T6Ŕ0.500	0.045	0.270	0.500	D3492-7
	M6061T6R1.000	0.045	0.750	0.938	D3492-9
	M6061T6R0.875	0.045	0.664	0.850	D3492-11
	M6061T6R0.750	0.045	0.510	0.750	D3492-13
$\neg$	M6061T6R0.875	0.050	0.640	0.850	D3492-15



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NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN AP DRAWING NO. CHECKED REV. E D3492 MFG. APPR. SHEET 2 OF 2 APPROVED SCALE **PLUG** DE APPR. 4:1 DATE 13.08.08

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